

Date: Monday, 02/03/2009 9:05:28 AM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STEP WELDMENT
Job Number : 46152
Estimate Number : 10779
P.O. Number :
This Issue : 02/03/2009 S.O. No. :
Prsht Rev. : NC
First Issue : / / Type : LARGE FAB ASSY
Previous Run : 46126
Written By :
Checked & Approved By : JUD 09.03.02
Comment : EST REV. A 05.11.18 new issue EC

Part Number : D3463041
Drawing Number : D3463 REV.B
Project Number : N/A
Drawing Revision : B
Material :
Due Date : 16/03/2009 Qty: 6 Um: EACH

(2)

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 238806 SS DOWEL PIN 1" LONG



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)
Pick:

Qty Part Number Description Batch
2 238-806 SS DOWEL PIN 1" LONG M105037

EL 9-3-23

(12)

2.0 D34533 Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
Pick:

Qty Part Number Description Batch
1 D3453-3 Clevis B46150

EL 9-3-23 (6)

3.0 D34637 Drag Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
Pick:

Qty Part Number Description Batch
1 D3463-7 Drag Arm B46271

EL 9-3-23 (8)

4.0 D34631 Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
Pick:

Qty Part Number Description Batch
1 D3463-1 Arm B46148

EL 9-3-23 (8)

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 02/03/2009 9:05:28 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 46152

Part Number: D3463041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34633

Step



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D3463-3 Step B44605

EL 9-3-23 x6

6.0

D34635

End Cap



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D3463-5 end cap B46270

EL 9-3-23 x12

7.0

D34535

Plug



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D3453-5 Plug B39720 x4
B46265 x2

EL 9-3-23 x6

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld assembly as per dwg D3463 using DT8875

CP 09-03-24

(P7C)

(x6)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-03-24 (4)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 02/03/24 (x6 46)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1- Mask areas indicated on dwg D3463 (holes, threads)

2-Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME:

7:55

FL 09/03/25 (16)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D3463-041 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 09/04/03

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: <u>46152</u> | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|-------------------|------|--|--------------------------------|--|-----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 09.03.23 | 8.0 | The D3453-34-5 are very tight to insert into the D3463-1 arm. RC: Material wall thickness inconsistent BUT is within tolerance. | MF 09/03/23 | Turn down the D3453-34-5 to allow them to insert into the D3463-1 arm by welding. Turn @ .755" $\pm .005$ - .000. | lpl 09.03.24 | <u>09.03.31</u> | MF 09/03/23 | <u>09.03.23</u> |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 02/03/2009 9:05:28 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 46152

Part Number: D3463041

Job Number:



Seq. #:

Machine Or Operation:

Description :

OVEN TEMPERATURE: 400°

FINISH TIME: 8:25

FL 09/03/25 (8)

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



11109917



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3463 and QSI 005 4.4

98 09-03-27 (x2)

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 09-03-30 (2)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST198A

88 09/03/30 (x2)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/01

Job Completion



MF
09-03-31

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

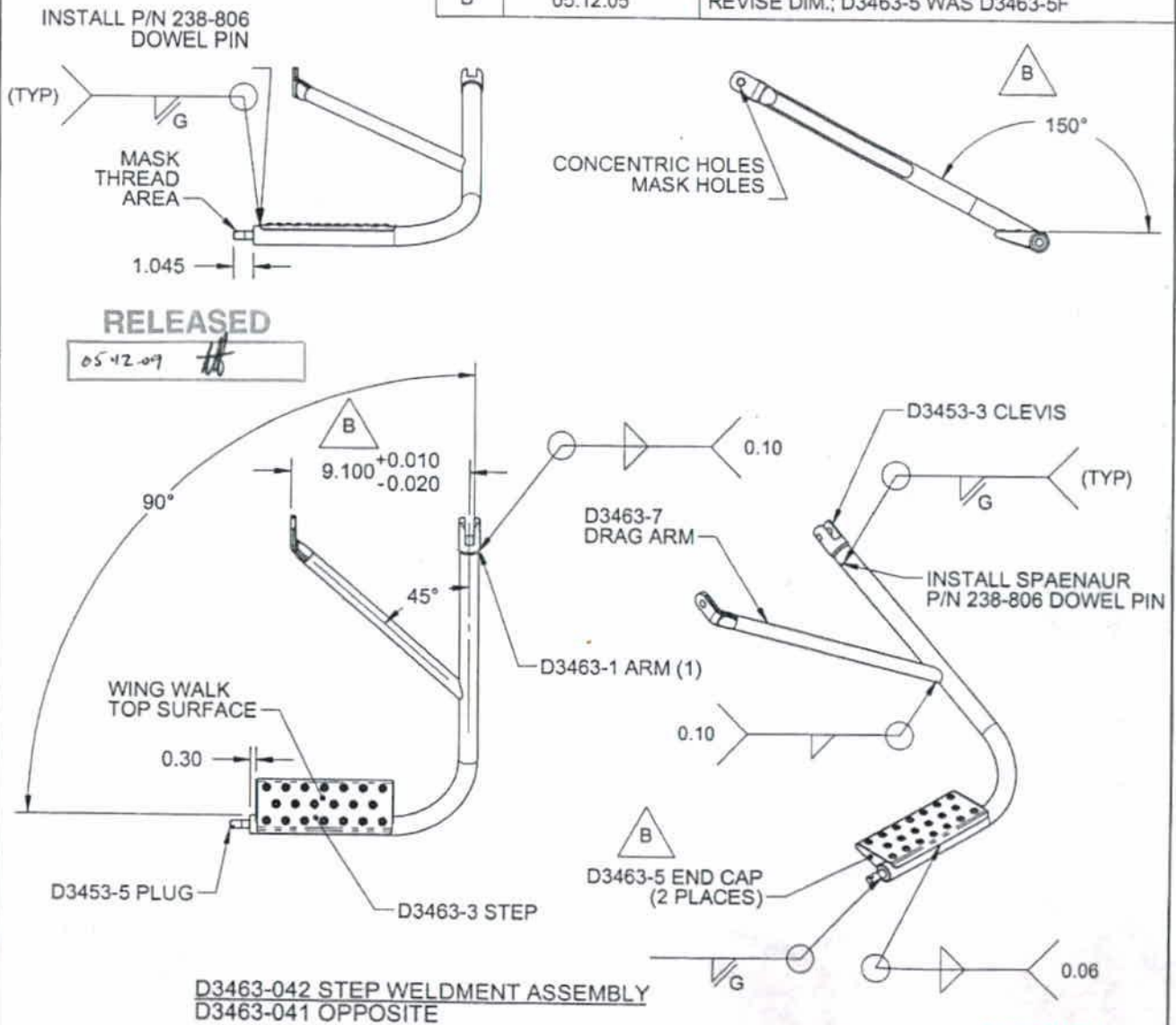
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

DART

| | | | |
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| CHECKED # | APPROVED # | DRAWING NO. D3463 | REV. B SHEET 1 OF 4 |
| DATE 05.12.05 | | TITLE STEP WELDMENT | SCALE 1:8 |
| A | 05.09.20 | NEW ISSUE | |
| B | 05.12.05 | REVISE DIM.; D3463-5 WAS D3463-5F | |

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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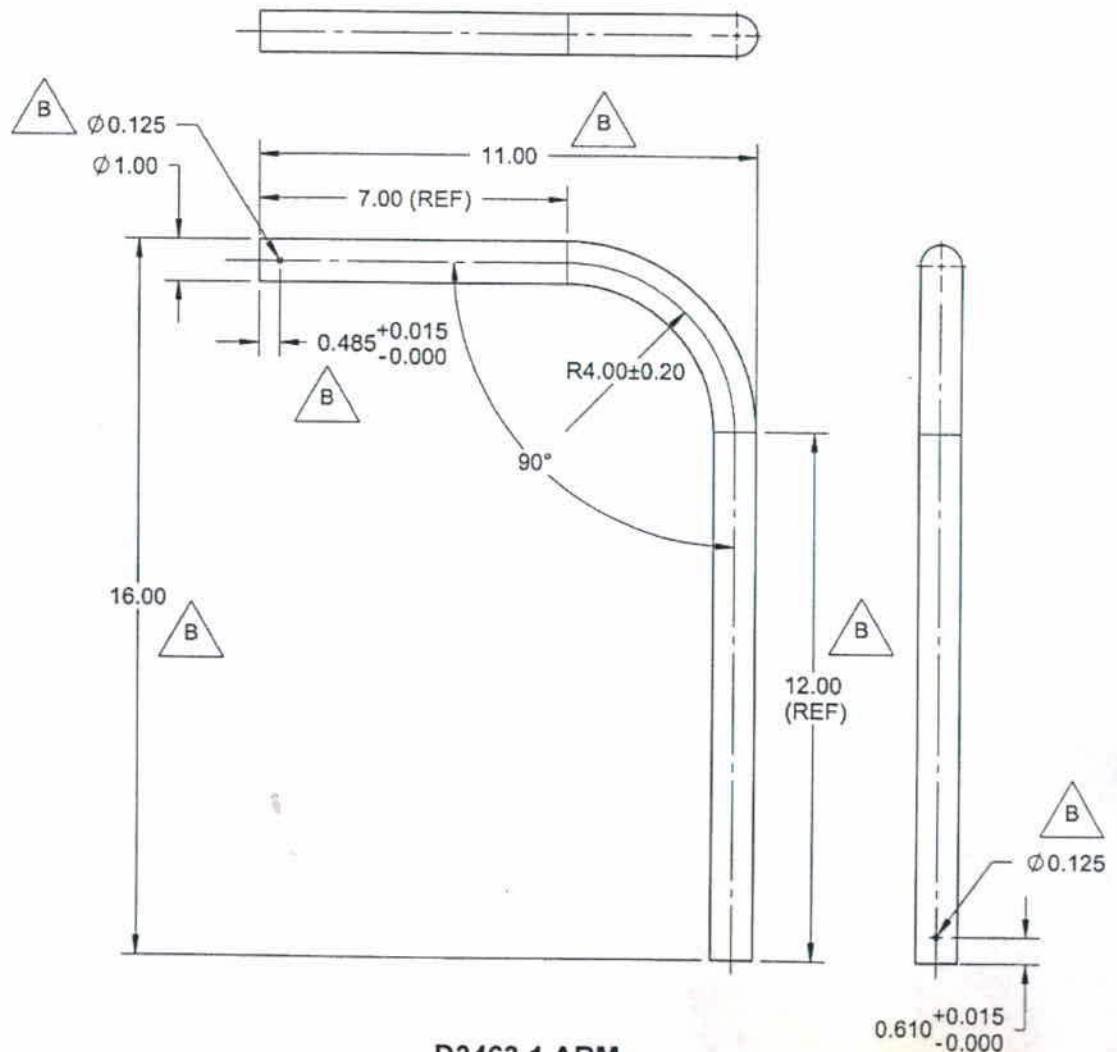
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| DATE 05.12.05 | TITLE STEP WELDMENT | | SCALE 1:4 |

RELEASED

05.12.05 *[Signature]***D3463-1 ARM****NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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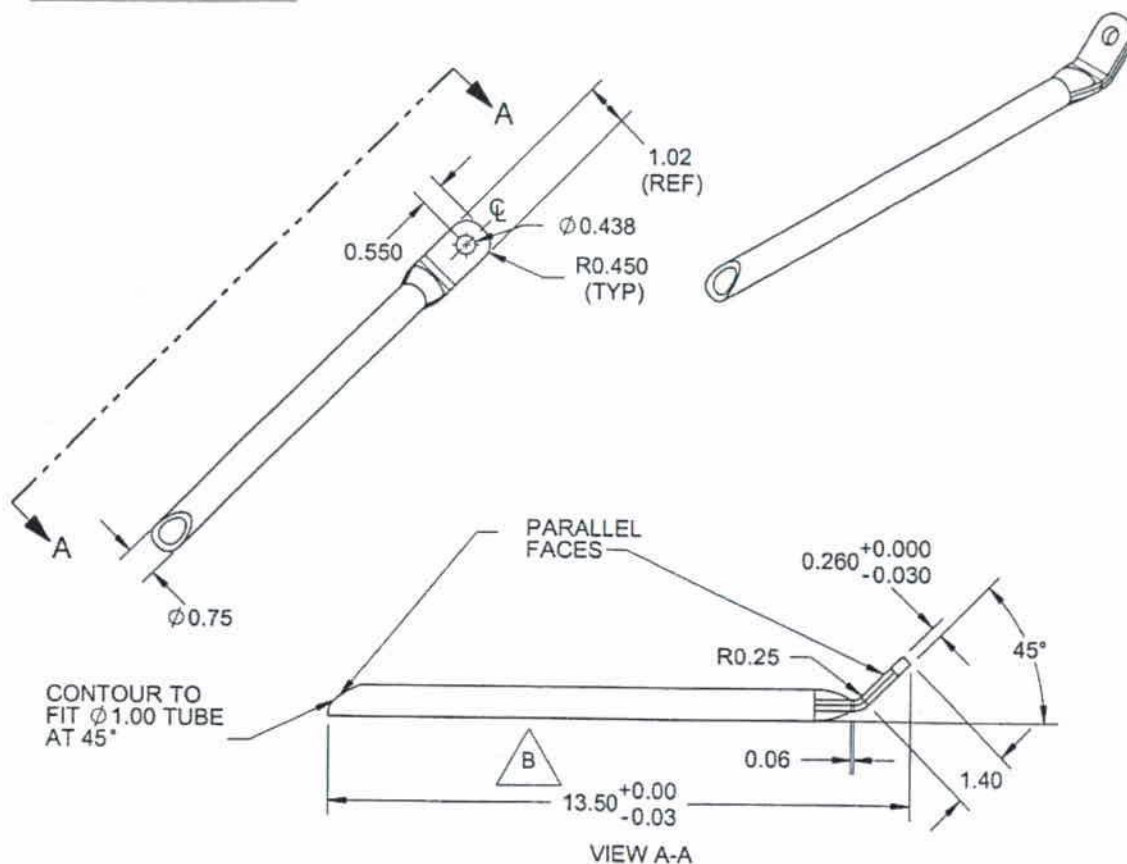
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| DATE 05.12.05 | TITLE STEP WELDMENT | | SCALE 1:4 |

RELEASED

05.12.05 #

**D3463-7 DRAG ARM****NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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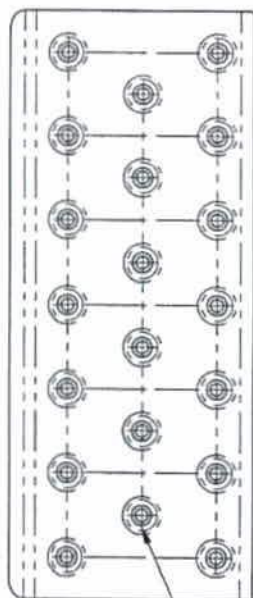
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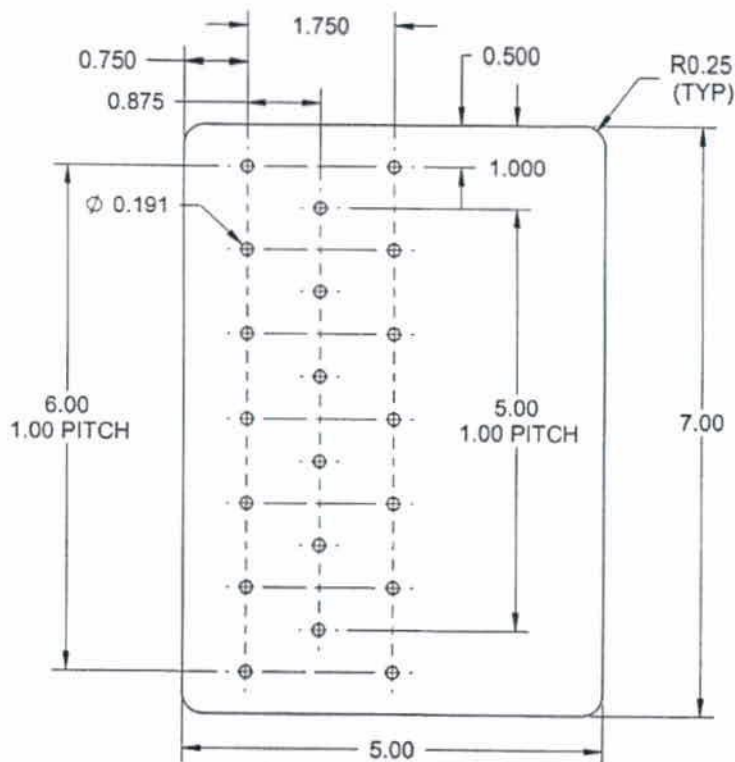
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| DATE 05.12.05 | | TITLE STEP WELDMENT | SCALE 1:2 |

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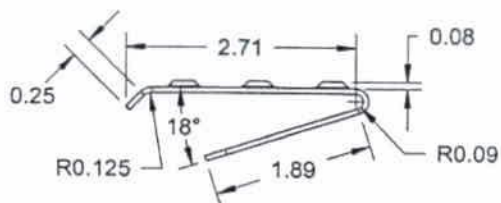
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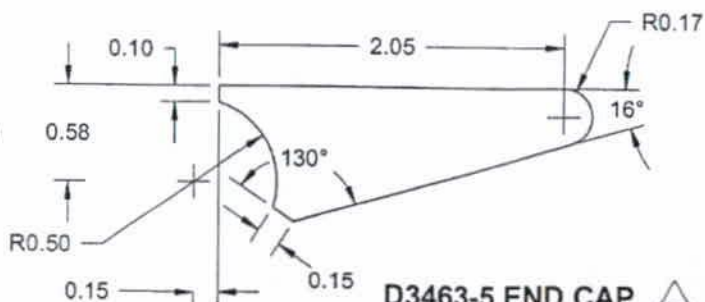
FORM USING
D3463-3T1



D3463-3F FLAT PATTERN



D3463-3 STEP



D3463-5 END CAP
SCALE 1:1

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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